

Date: Thursday, 2/22/2007 2:58:45 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	FITTING	
Job Number	30834				
Estimate Number	10438				
P.O. Number	N/A		Part Number	D32991	
This Issue	2/22/2007		S.O. No.	N/A	
Prsh Rev.	NC		Drawing Number	D3299 REV A/B	
First Issue	N/A		Project Number	N/A	
Previous Run	N/A		Drawing Revision	A/B	
Written By			Material	N/A	
Checked & Approved By			Due Date	3/20/2007	
Comment	Est: A 04.10.04 New issue KJ/JLM		Qty:	6	Um: Each

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6H1625	6061T6 hex bar 1.625
	Comment: Qty.: 0.2013 f(s)/Unit Total : 1.2077 f(s) 6061T6 hex bar 1.625 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.625" Hex (M6061T6H1.625) Identify as D3299-1	Batch: M17625 DSP 07/06/04 12
2.0	HARDINGE → Band saw	HARDINGE CNC LATHE SMALL
	Comment: HARDINGE CNC LATHE SMALL → Band saw Cut blank: 2.200" long Turn as per Folio FA451 and Dwg D3299	DSP 07/06/04
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	BAND SAW → Deburr	BAND SAW
	Comment: BAND SAW Deburr Machine as per Folio FA451 and Dwg D3299 Deburr	NB / DSP 07/06/04 12
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SC / NB 07/06/04 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/06/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/08	4.0	1 part scrap - cut like 90° too deep  1-part scrap during turning threads no gear.	07/06/08	- raise tool offset 2 scrap no replace	SA 07/06/08	07/06/11	07/06/11	07/06/11

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 30834

Part Number: D32991

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 07/06/11

7.0 OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 3943

Anodize as per Dwg D3299

Possible Supplier: TNM Paint

Material release note is required

c/o 07/06/11 (10)

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

*G. S. 07/06/18 (10)*

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*11 07-06-09 10*

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SF 90

*C 7/6/19 S9 (10) (D)*

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*7/8/19*

Job Completion



*11 07-06-19*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	30834
Description: Fitting	Part Number:	D3299-1
Inspection Dwg: D3299 Rev: BTB		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

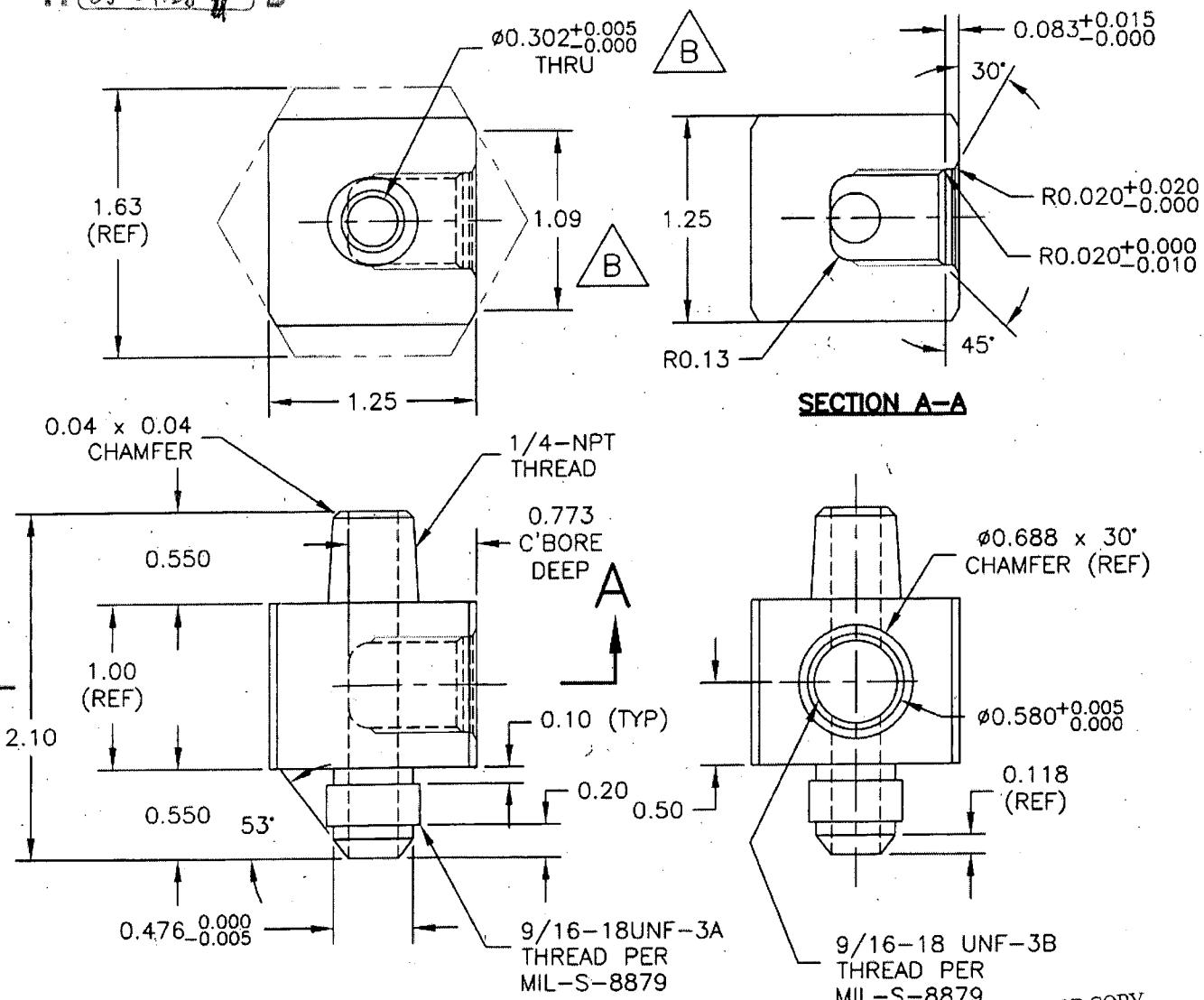
Measured by:	MSTB	Audited by:	mk	Prototype Approval:	N/A
Date:	07/06/09	Date:	07/06/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.312; 1.09 added	KJ/JLM	



DESIGN <i>P</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; Ø0.302 WAS Ø0.297	

RELEASED  
05.04.28



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 UNCONTROLLED COPY POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER  
NO. 30834

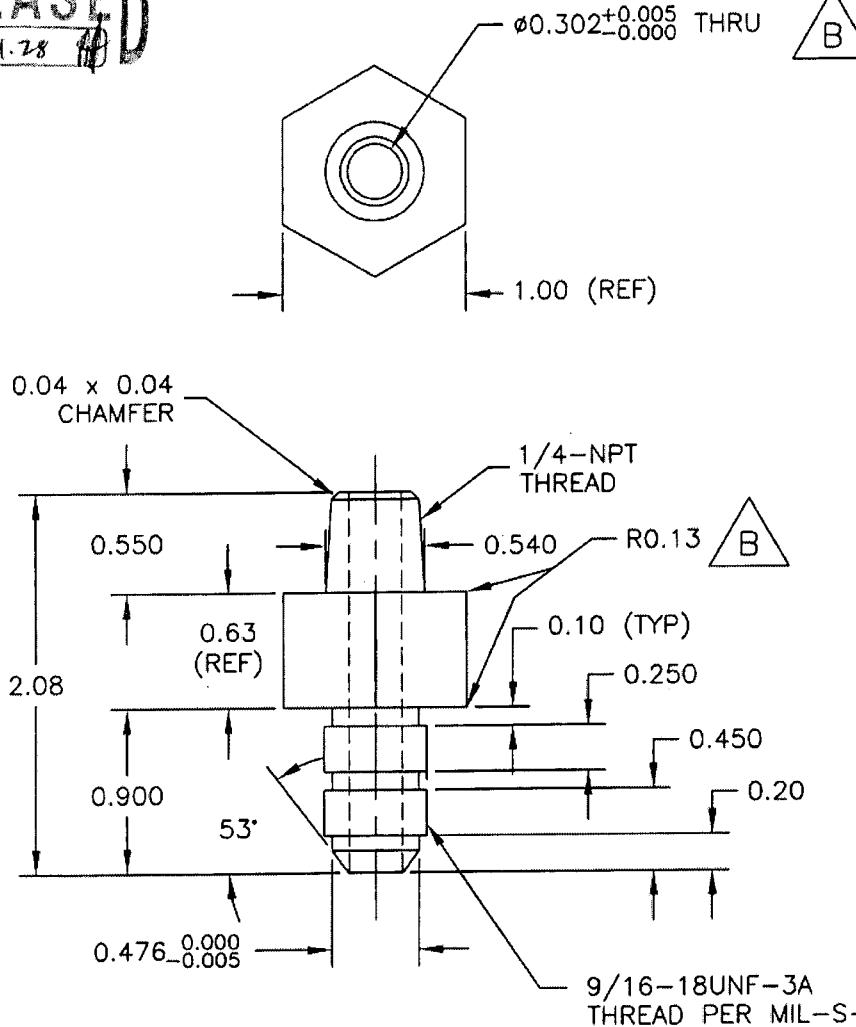
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED  
05.04.28



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1R000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS III
- 3) POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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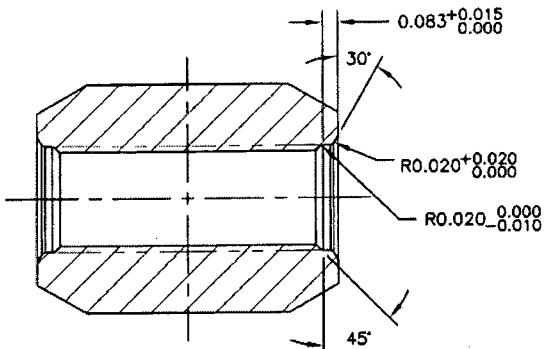
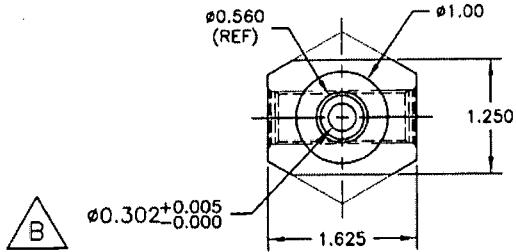
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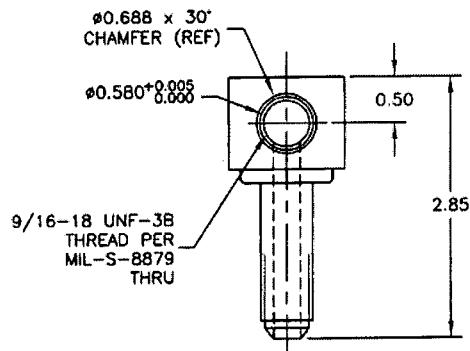
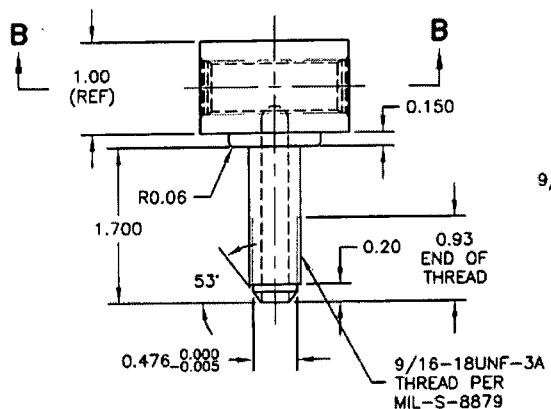


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		DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28	TITLE FITTING	SCALE 1:2	

RELEASED  
05.04.28 *[Signature]*



SECTION B-B  
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2  
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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TNM

**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2  
 Telephone: (514) 429-7777 Fax: (514) 429-5108  
 Certifié ISO 9001-2000 / AS9100 certified  
 approuvé NADCAP approved

56196

14-Jun-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.  
 1270 ABERDEEN STREET  
 HAWKESBURY ONTARIO  
 K6A 1K7

**CERTIFICATE OF COMPLIANCE**  
**CERTIFICAT DE CONFORMITE**PURCHASE ORDER/  
NO. DE COMMANDE: 00003943

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	10	10 D3299-1	B30834	BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

*W**W*

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.  
 Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.  
 Travel cards have been filed and are available for viewing upon request.

Signature/Signed:

 Directeur de la Qualité / Q.A. Manager